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RBW6305G03531-3G
Job Sheet 184903



Part No: RBW6305G03531-3G

Job Qty: 3 ea

Part Name: AW139 Input Flange/Gimbal Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 10/30/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBW6305G03531-3G Rev. D IPP Rev. A 18.09.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		10/30/18	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	3 pcs		10/30/18	0.00	3.00	Small Fab-4		
120	QC	3 pcs		10/30/18	0.00	0.00	QC5		
130	Packaging	3 pcs		10/30/18	0.00	0.00	Packaging3-1		
140	QC21-FG	3 Ea		10/30/18	0.00	0.00	QC21		

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6305G03531-3G-4 to RBW6305G03531-3G-2foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	12 Ea (4 ea)	90-Start up Operation	5089128
APP-1700-E	Case	3 Ea (1 ea)	90-Start up Operation	5126592 - 5126589
RB41011	Dart Tooling Placard, Aluminum	3 Ea (1 ea)	90-Start up Operation	3021010
RBW6305G03531-3G-2	Top Foam	3 (1 ea)	90-Start up Operation	5126590 - 5126587
RBW6305G03531-3G-3	Bottom Foam	3 (1 ea)	90-Start up Operation	5126591 - 5126588
RBW6305G03531-3G-4	Location Placard 1	3 Ea (1 ea)	90-Start up Operation	5126699
RBW6305G03531-3G-5	Location Placard 2	3 Ea (1 ea)	90-Start up Operation	5126702
RBW6305G03531-3G-6	Hardware Assembly	3 Ea (1 ea)	110-Small Fab	5129595
RBW6305G11331-3G	Main Gear Box Input Pinion Ring Nut Wrench	3 Ea (1 ea)	110-Small Fab	5127805
RBW6305G11631-3G	Puller, Main Gear Box Input Flange Remover	3 Ea (1 ea)	110-Small Fab	5127818
RBW6305G11731-3G	Pusher, Main Gear Box Input Flange Installer	3 Ea (1 ea)	110-Small Fab	5127824
RBW6305G11831-3G	Puller, Main Gear Box Input Gimbal Removal	3 Ea (1 ea)	110-Small Fab	5127807



Container No: S128231



Part: RBW6305G03531-3G

Job No: 184903

Serial No/Batch: S128231

Revision: D

Inspector:

Exp Date:

Instructions:

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Date: 11/15/18

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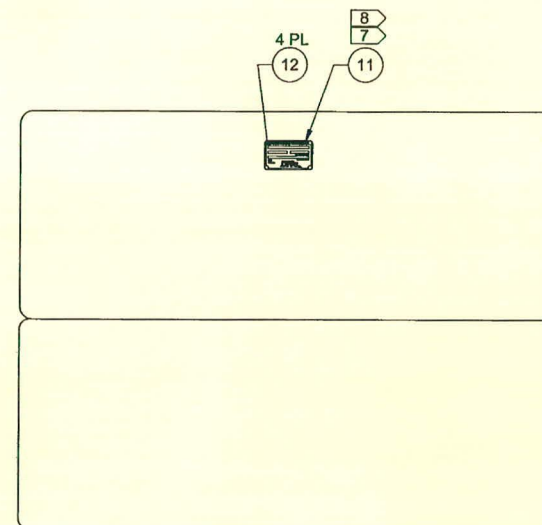
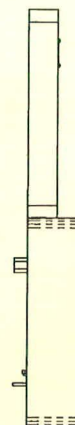
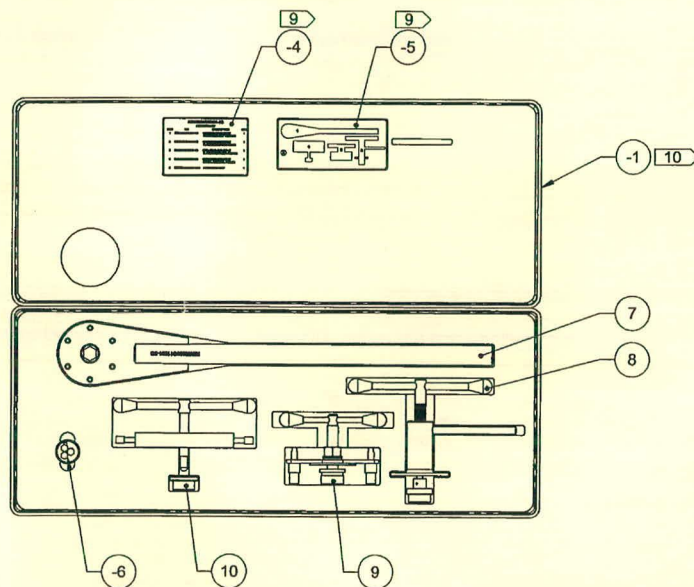
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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	12	819	0
	APP-1700-E	3	19	0
	RB41011	3	743	0
	RBW6305G03531-3G-2	3	0	0
	RBW6305G03531-3G-3	3	0	0
	RBW6305G03531-3G-4	3	0	0
	RBW6305G03531-3G-5	3	0	0
	RBW6305G03531-3G-6	3	0	0
110-Small Fab	RBW6305G11331-3G	3	0	0
	RBW6305G11631-3G	3	0	0
	RBW6305G11731-3G	3	0	0
	RBW6305G11831-3G	3	0	0
Part Specifications				
Specifications could not be found.				

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ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6305G03531-3G-1	PACKAGING ASSY
-4	1	RBW6305G03531-3G-4	LOCATION PLACARD 1
-5	1	RBW6305G03531-3G-5	LOCATION PLACARD 2
-6	1	RBW6305G03531-3G-6	HARDWARE ASSY
7	1	RBW6305G11331-3G	MAIN GEAR BOX INPUT PINION RING NUT WRENCH
8	1	RBW6305G11631-3G	MAIN GEAR BOX INPUT FLANGE REMOVER PULLER
9	1	RBW6305G11731-3G	MAIN GEAR BOX INPUT FLANGE INSTALLER PUSHER
10	1	RBW6305G11831-3G	MAIN GEAR BOX INPUT GIMBAL REMOVAL PULLER
11	1	RB41011	DART PLACARD
12	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



RBW6305G03531-3G AW139 INPUT FLANGE/GIMBAL REPLACEMENT TOOL KIT

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 9) HOT GLUE THE PLASTIC PLACARD ONTO THE TOP FOAM
- 10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

D	TEMPLATE PER DART STANDARDS, P/N CHANGED PER DART STANDARDS, SEE PREVIOUS PDFs REV FOR INFOS		18-795	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VM			
CHECKED	VM	TOOL PART #	REV. F	
MFG. APPR.	DP	RBW6305G03531-3G	SHEET 1 OF 7	
APPROVED	VM	TITLE	SCALE	NTS
		AW139 INPUT FLANGE/GIMBAL REPLACEMENT TOOL KIT		
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